

Work Order ID 56669

March 4, 2010 11:04:07 AM



Page 1

Item ID: D3785-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 3/04/10

Start Qty: 10.00



Cust Item ID:

Required Date: 3/10/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3785

Rev D

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3785

Dwg Rev: BProg Rev: B

grain along 10.669

2-Deburr if necessary

B 10-3-8

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 10-3-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC8- Inspect parts - second check

0.00

8/10/03/08

QC

Quality Control

Memo

0.00

(+12)

130



Brake NC

Brake NC

Memo
1- bend per dwg

0.00

0.00

8/10/03/10

(12)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/03/11

Memo

0.00

(412)

W/O:		WORK ORDER CHANGES					
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Work Order ID 56669

March 4, 2010 11:04:08 AM



Page 3

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Item Name: Bracket

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Start Date: 3/04/10

Start Qty: 10.00



Cust Item ID:

Required Date: 3/10/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

PR 10-3-15

(12) 0

Memo

0.00

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

Start Time: 3:55
Oven Temperature: 300°
Finish Time: 3:25

0.00

PR 10-03-15

(12) 0

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

HL 10-03-16

(X12) 0

W/O:		WORK ORDER CHANGES					
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Start Date: 3/04/10

Start Qty: 10.00



Required Date: 3/10/10

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Identify as per dwg & Stock Location: *ST088*

0.00

Memo

0.00

CY 10/3/16 (12)

Packaging

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/17
MF 10-3-16

W/O:		WORK ORDER CHANGES					
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Picklist Print

March 4, 2010 11:04:06 AM

Page 1

Work Order ID: 56669

Parent Item: D3785-1

Parent Item Name: Bracket



Comments: IPP Rev:A 08-05-01 new issue DD verified by:EC

Start Date: 3/04/10

Required Date: 3/10/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080 		Purchased	No			100	sf	134.6997	5.6842	7.		
6061-T6 .080 Sheet												

B10-3-8

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

134.69967

110630

35.0136

112141

0.86727

112763

0.19

113438

98.6288

13438

10

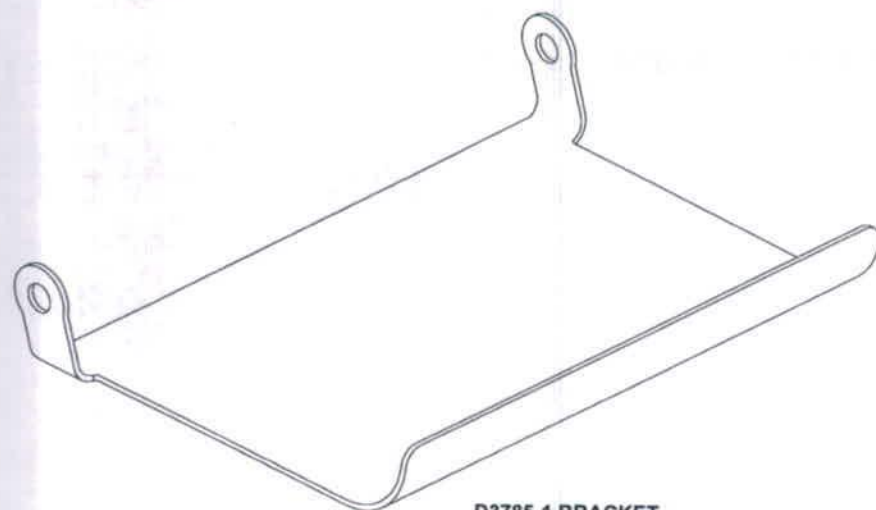
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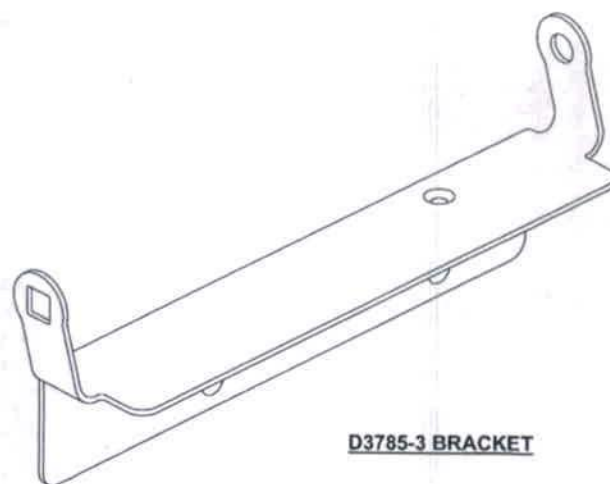
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D3785-1 BRACKET



D3785-3 BRACKET

Wb 56669

RELEASED
2009-12-02
mp

D	REVISED D3785-3 AS FOLLOWS: 1.13 WAS 1.05 (ZN C2-3); 1.500 WAS 2.000 (ZN B7-3); 5.500 WAS 6.750 (ZN B5-3); REASON: PROVIDE MORE CLEARANCE FOR CUSHION UPON ASSEMBLY AND HOLE PATTERN NOT MATCHING D3781-1 HOLE PATTERN.	MB	09.11.26
C	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.07
B	REDESIGNED D3785-3; REMOVED P/Ns D3785-0411-11-SI-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3785	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	09.11.26	<small> COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

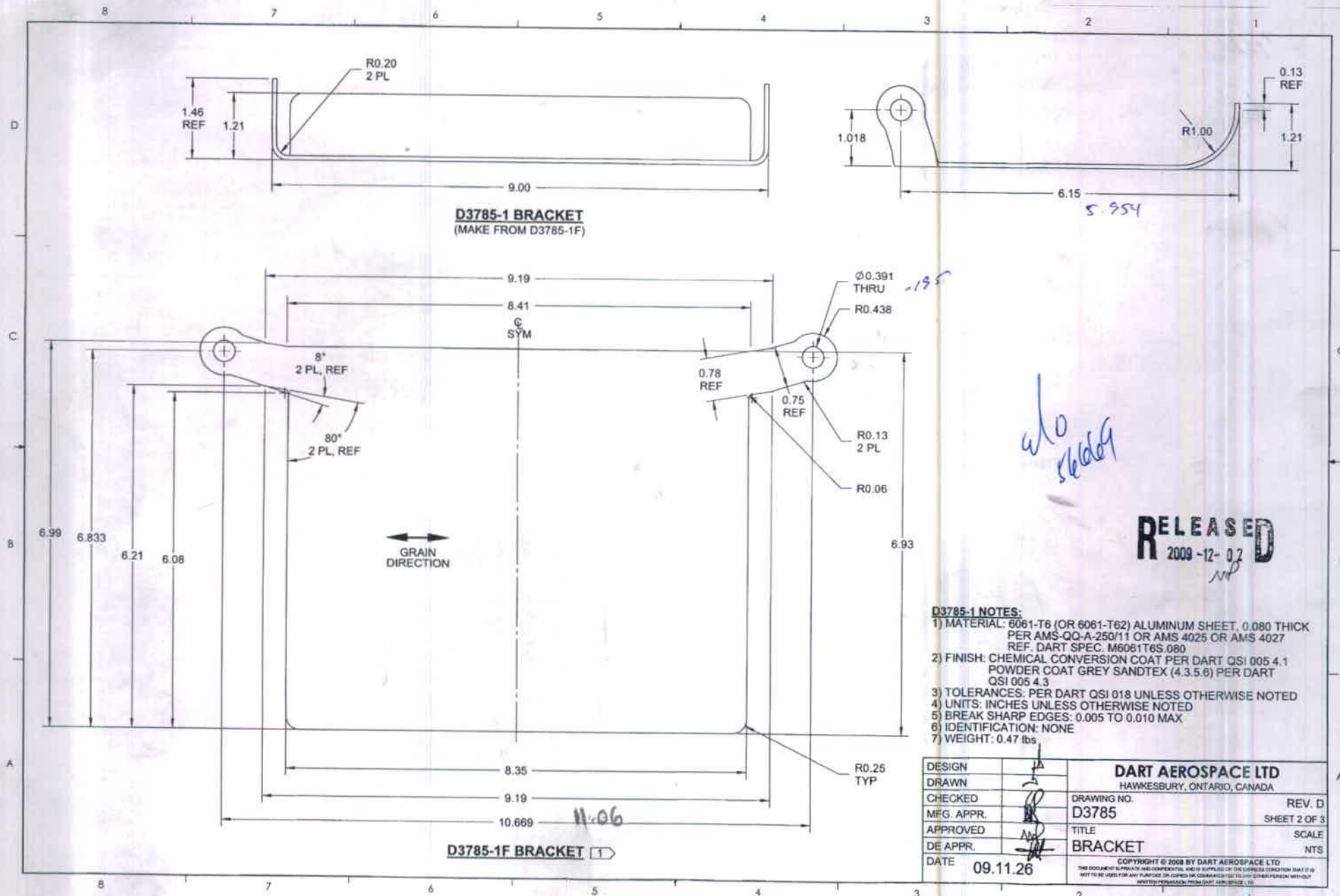
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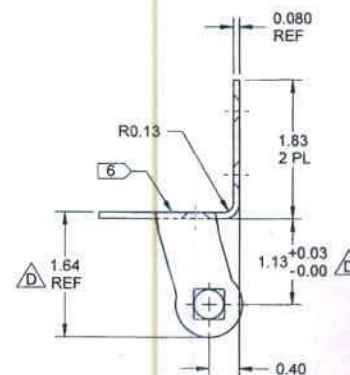
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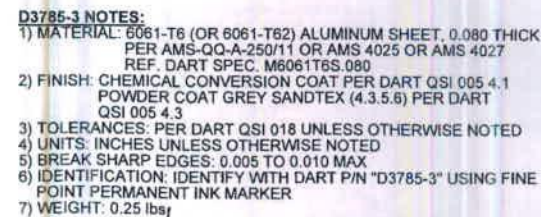
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RELEASE
2009-12-02

D3785-3F FLAT PATTERN ☐ 1

DESIGN	<i>A</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3785 TITLE BRACKET COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY USE OR DISSEMINATION OF THIS DRAWING OR ANY INFORMATION CONTAINED HEREIN WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD IS PROHIBITED.	REV. 1
DRAWN	<i>B</i>		SHEET 3 OF 3
CHECKED	<i>PH</i>		SCALE
MFG. APPR.	<i>NS</i>		NTS
APPROVED	<i>NS</i>		
DE APPR.	<i>NS</i>		
DATE	09.11.26		

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